

Work Order ID 77557

December-13-11 1:41:55 PM

77557

Page 1

Item ID: D2947

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Clamp

Start Date: 13/12/2011 Start Qty: 50.00

50

Cust Item ID:

Required Date: 20/12/2011 Req'd Qty: 50.00

50

Customer:

Reference:

Approvals: Process Plan: MLJ Date: 11/12/13 Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D2947	Rev A1

100 0.00

100

PURCHASING

Waterjet

Memo

0.00

B11-12-20

FLOW CNC Waterjet

1-Cut as per Dwg

Dwg Rev: A1

Prog Rev: A1

304.063

2-Deburr if necessary

(50)

110

QC2- Inspect parts off machine FAI/FAIB

0.00

110

QC

Memo

0.00

B11-12-20

Quality Control

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Item ID: D2947 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Clamp
 Start Date: 13/12/2011 Start Qty: 50.00 ***50*** Cust Item ID:
 Required Date: 20/12/2011 Req'd Qty: 50.00 ***50*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120 *120* QC Quality Control	QC8- Inspect parts - second check Memo	0.00 0.00		SB 11/12/20		count (57)			
130 *130* Brake NC Brake NC	Bend as per dwg Small Fab Memo	0.00 0.00		SB 11/12/21		(50)			
150 *150* QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00		SB 11/12/21		count (50)			

W/O:		WORK ORDER CHANGES					
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NOTE: Date & initial all entries

Work Order ID 77557***77557***

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Cust Item ID:

Required Date: 20/12/2011 Req'd Qty: 50.00

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Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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160 Identify as per dwg & Stock Location: **ST 450** 0.00***160***

Packaging

Memo

0.00

Packaging

170 QC21- Final Inspection - Work Order Release 0.00

170

QC

Memo

0.00

Quality Control

(50x)**SP 11-12-21****11/12/22**
MF 11-12-22

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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NOTE: Date & initial all entries

December-13-11 1:42:00 PM

77557

D2947

Required Qty: 50.00

11.08.08. MADE IN HOUSE DD VEF :EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S16GA		Purchased	No			100	sf	150.8300	0.062	3.263158			
M304S16GA									**	B11-12-20			
304/316 Sheet .063													
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				MAT020		150.83							
				119653		150.83			119653				

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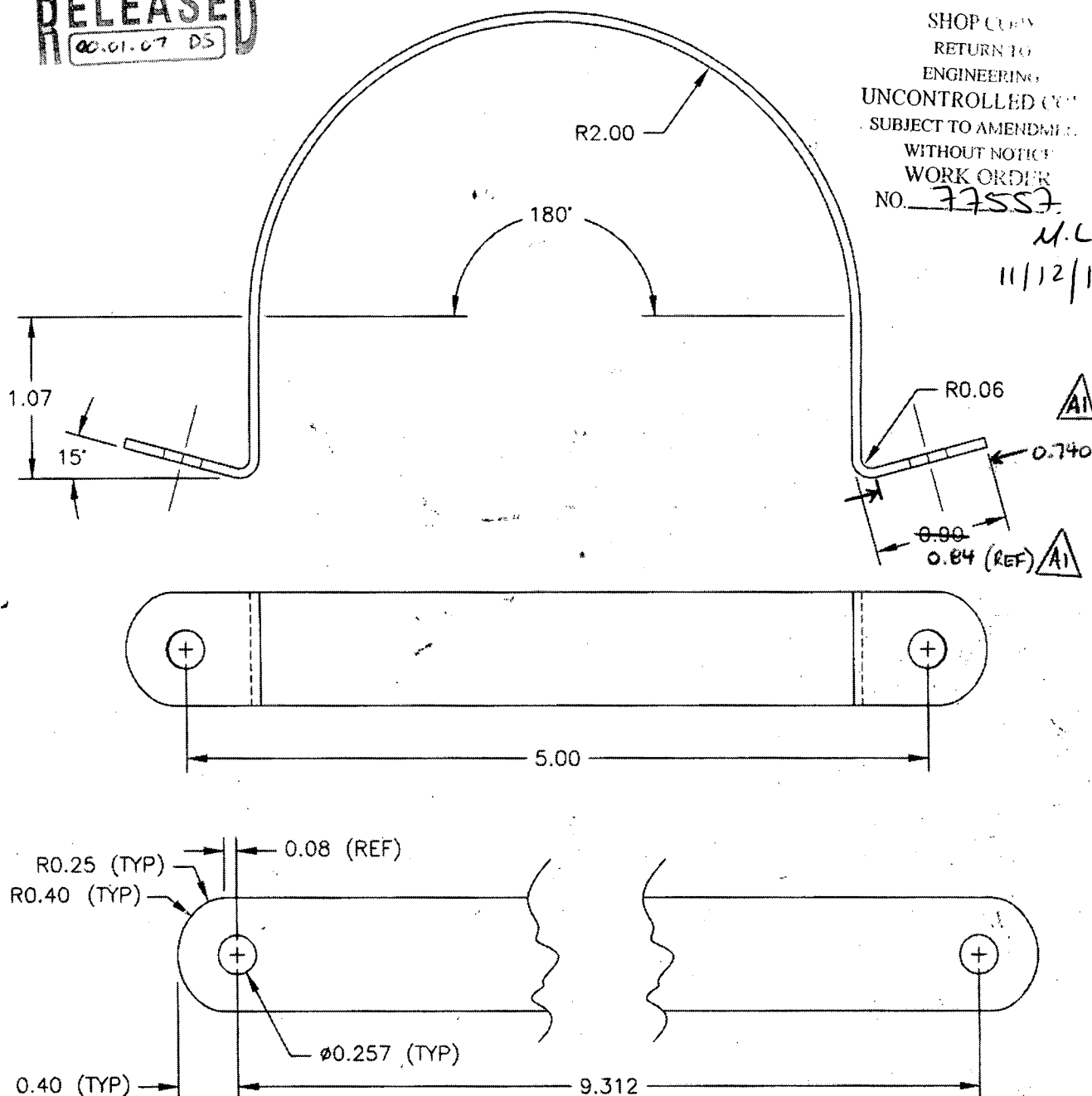


DESIGN <i>[Signature]</i>	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2947	REV. A SHEET 1 OF 1
DATE 00.01.06		TITLE CLAMP	SCALE 1:1
A	00.01.06	NEW ISSUE	

RELEASED
00.01.07 DS

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 77557

M.L.J
11/12/13



D2947 FLAT PATTERN

MATERIAL: AISI 304/316 SS 0.063 THICK x 0.75 WIDE
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
ALL DIMENSIONS ARE IN INCHES

W/O:		WORK ORDER CHANGES					
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